



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-14181W6-1
Job Sheet 185251



7314
Nov 2018

Part No: RBE105-14181W6-1

Job Qty: 5 ea

Part Name: Plunger



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-14181W6 Rev.1 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-2		Free 18-11-5
110	Lathe Conv	5 pcs	11/9/18	11/9/18	0.00	1.25	Lathe Conv-1		Free 18-11-5
120	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC2 Machining-4		Free 18-11-5
130	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC8 Machining-4		Free 18-11-05
140	Outsource	5 pcs	11/9/18	11/9/18	0.00	0.00	Outsource13		Free 18-11-13
150	Packaging	5 pcs	11/9/18	11/9/18	0.00	0.00	Packaging2		NOV 28 2018
190	QC	5 pcs	11/9/18	11/9/18	0.00	0.00	QC6		38
200	Packaging	5 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1		11/10/18
210	QC21-SA	5 Ea	11/9/18	11/9/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. DWG REV: 2-Debur
Descriptions: 130 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
140 - Issue P/O to GROUPE ALTECH: P/O 041722 -Zinc plate, ASTM B633 TYPE 1 SC2-Color; Clear -Material type; 1018 -Certificate of Conformity is required

DAS
2T
DEC 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018R0.750	M1018R0.750	2.2150 ft (.443 ea)	90-Start up Operation	2000799

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M1018R0.750	2	20	0

Part Specifications

d not be found.

Plex 10/24/18 11:12 AM Dart.lajeunesse.marie



Container No: S124615



Part: RBE105-14181W6-1

Job No: 185251

Serial No/Batch: S124615

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/05/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

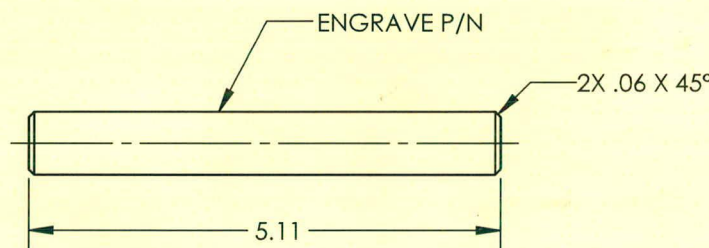
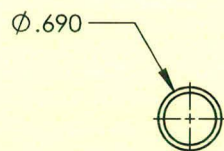
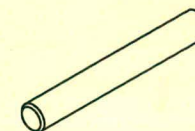
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 185257 MLS
18-10-24



(-1)
 PLUNGER

DART AEROSPACE	
TITLE PUSHING-OUT TOOL	
DWG NO. RBE105-14181W6-1	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± .5°
DRAWN BY: CLOUGH	.X ± .1 SURFACES = 125/
CHECKED: DUERFELDT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL EC145
SCALE 1:2	DATE 1/13/2016 SHEET 2 OF 7

Decembre 14th Shipping..



DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>185247</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. <u>RBE105-14181WS-1</u> <u>PR slip error</u>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. <u>RBE10514181W6-1</u>		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☒		

Date: <u>NOV 23 2018</u>	Step #: <u>190</u>	QTY Effective: <u>5</u>	MRB (QSI042) Approval DAS 9 9-89 <u>18-11-23</u>
--------------------------	--------------------	-------------------------	---

Description Work Order Deviation <u>- ALL PARTS HAVE UNPLATED WIRE HANGER MARKS</u>	Disposition <u>not acceptable.</u> <u>Parts to be return to supplier</u> <u>to be rework.</u> <u>** notify supplier that mark is not acceptable **</u> <u>Parts found to be acceptable. see Email.</u>	Completed By Lead hand / Supervisor Approval Verification <u>18-11-29</u> QC / QA Coordinator Approval <u>18-11-29</u>
---	--	---

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☒	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☒	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER : _____					

1000

1000

1000

1000

1000

1000

1000

1000

1000



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041722**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041722
PO Date: 11/14/18
Due Date: 11/28/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185247	RBE105-14181W5-1	Plunger -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/28/18	5 pcs	0 pcs	5 pcs	\$17.142857/pcs	\$85.71
						5X NOV 27 2018					
						NOV 21 2018					
2	185251	RBE105-14181W6-1	Plunger -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	11/28/18	5 pcs	0 pcs	5 pcs	\$17.142857/pcs	\$85.71
						5X NOV 28 2018					
3	269T9310-3	Handle	-Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color BLACK -Certificate of Conformity is required * confirm if pick up for 27 is ok*	Firmed	-	11/27/18	4 pcs	0 pcs	4 pcs	\$17.142857/pcs	\$68.57
						4X NOV 20 2018					
Grand Total:											\$240.00

DAS
38
9-89

11/15/2018

PURCHASE ORDER



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO041722

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

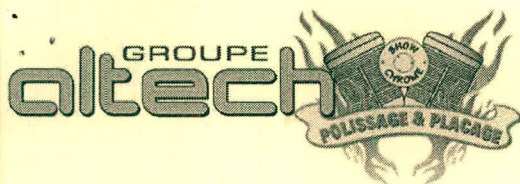
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/15/18 1:45 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(014452-3)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

014452- 3

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
27-Nov-2018		Aman		041722					
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities		À venir/ Back Order	
						Qté NC/ NC Qty	Qté Scrap/		
2	RBE105-14181W6-1 Rev.	RBE105-14181W6-1 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 TYPE 1 SC2 MATERIAL 1018	ZINC CH	5	5	0	0	0	

 DAS
 38
 9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Patrick Duval

From: Michael Lee
Sent: Tuesday, November 27, 2018 12:17 PM
To: Jean-Luc Menard; Chrisoula Tsimiklis; Patrick Duval; Ketan Tailor
Subject: RE: RBE105-14181W6-1

I agree with JL.

@Ketan; can you please add this drawing to the sustaining engineering que.

Cheers,

Mike

From: Jean-Luc Menard <jmenard@dartaero.com>
Sent: Tuesday, November 27, 2018 11:39 AM
To: Chrisoula Tsimiklis <ctsimiklis@dartaero.com>; Michael Lee <mlee1@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Subject: RE: RBE105-14181W6-1

Mike,

I would say yes for this time but I think we should review the dwg to go to SS for the next time around.

Agree?

JL

From: Chrisoula Tsimiklis <ctsimiklis@dartaero.com>
Sent: Tuesday, November 27, 2018 11:34 AM
To: Jean-Luc Menard <jmenard@dartaero.com>; Michael Lee <mlee1@dartaero.com>; Patrick Duval <pduval@dartaero.com>
Subject: FW: RBE105-14181W6-1
Importance: High

Hi Guys,

Response or the barrel plating below. Do we get them back and use them as is?

From: ILYAN <inspection@groupaltech.com>
Sent: Tuesday, November 27, 2018 11:33 AM
To: Chrisoula Tsimiklis <ctsimiklis@dartaero.com>
Cc: info@groupaltech.com
Subject: FW: RBE105-14181W6-1
Importance: High

Good Morning Chrisoula,

The barrel plating will damage the parts because they are heavy, please let us know if you want them back as is,

Merci / Thank you,

Iliyan Blanko
Inspection
2455 Halpern,
St-Laurent, QC,
H4S 1N9
Tel: (514) 335-3666
Fax: (514) 335-3868
sales@groupaltech.com
www.groupaltech.com



Canada

Programme des marchandises contrôlées
Controlled Goods program

From: INFO [<mailto:info@groupaltech.com>]
Sent: Tuesday, November 27, 2018 10:34 AM
To: 'ILYAN'
Subject: FW: RBE105-14181W6-1
Importance: High

From: Chrisoula Tsimiklis [<mailto:ctsimiklis@dartaero.com>]
Sent: November 27, 2018 8:17 AM
To: INFO
Subject: RBE105-14181W6-1
Importance: High

Good morning Aman,

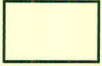
Sorry to take so long to get back to you and Iliyan on this, but we are wondering if you guys offer barrel plating instead of rack plating?

Let me know,

Thanks!

Chrisoula Tsimiklis
Junior Buyer
DART AEROSPACE

T 1-613-632-5200 Ext. 298
www.dartaerospace.com



Virus-free. www.avast.com

This e-mail message has been scanned by SEG Cloud
